

Date: Friday, 01/08/2008 10:42:39 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARSHOE
<b>Job Number</b>	: 40897		
<b>Estimate Number</b>	: 10314		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D265613
<b>This Issue</b>	: 01/08/2008	<b>Drawing Number</b>	: D2656 REV D
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Drawing Revision</b>	: D
<b>Previous Run</b>	: 38747	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/08/2008
<b>Checked &amp; Approved By</b>	: <u>JLD 08.8.05</u>	<b>Qty:</b>	20
<b>Comment</b>	: Est: F 02.10.25 Re-format KJ/RF	<b>Um:</b>	Each
	: Est Rev:G Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S20GA	1010/1025 SHEET
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**Comment:** Qty.: 0.8500 sf(s)/Unit Total : 17.0000 sf(s)  
 1010/1025/A21/6aA SHEET

108275 HB 8-8-18

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2656  
 Dwg Rev: B  
 Prog Rev: B

HB 8-8-18

(26)

2-Deburr if necessary

HB 8-8-18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-18

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

Soldered 19 (26)

counter

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326  
 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

SB 08/08/19 (26)  
 08/08/19 (26)

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:39 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 40897

Part Number: D265613

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



coater

Comment: INSPECT WORK TO CURRENT STEP

S 08/08/19 (26)

7.0

POWDER COATING

POWDER COATING



106442



(26X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-20  
320  
8-50

M-L 08/08/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

48 08-08-20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(26X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 20

M-L 08/08/20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40897
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-13
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

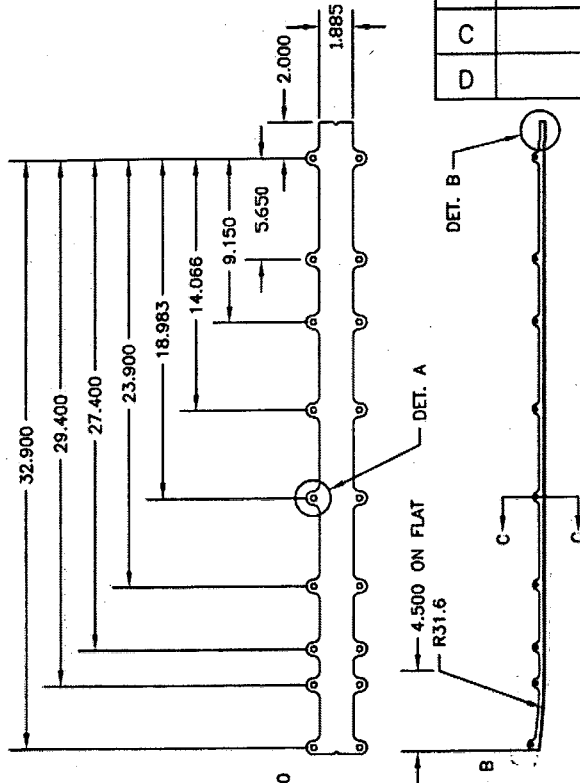
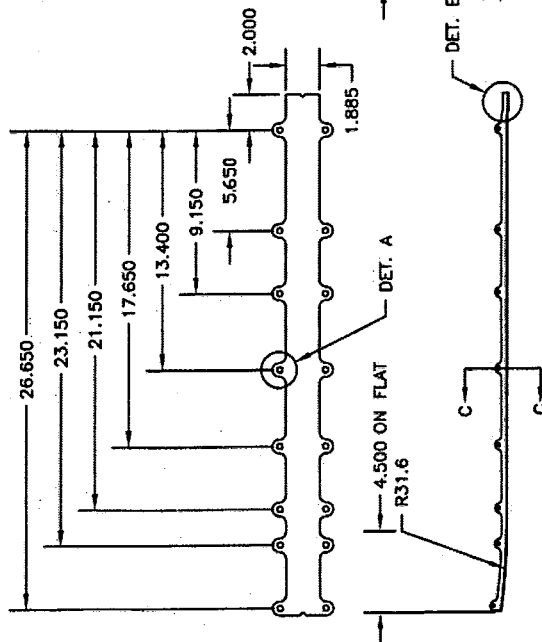
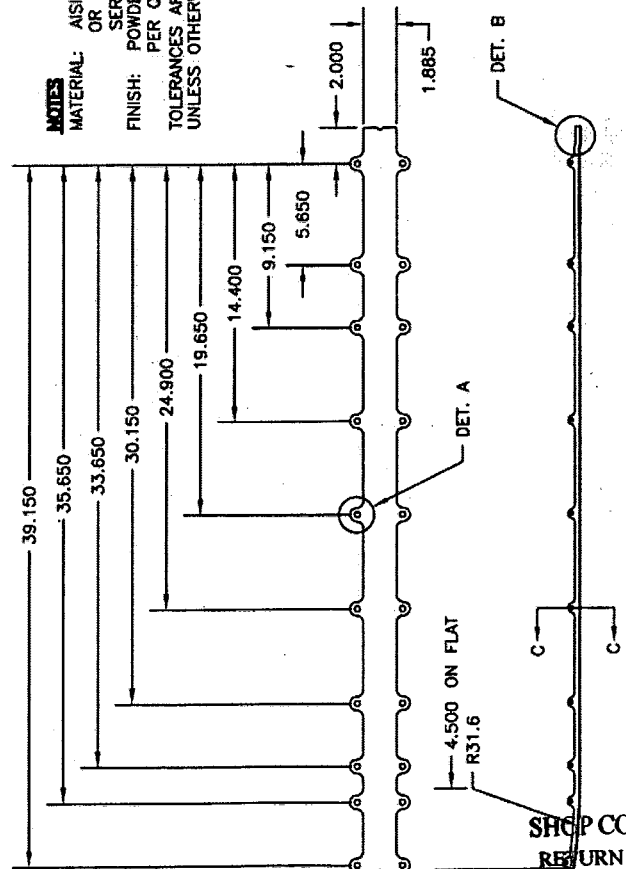
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	X			
5.650	+/-0.010	5.656	X			
9.150	+/-0.010	9.150	X			
0.300	+/-0.010	.305	X			
0.300	+/-0.010	.304	X			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-8-18	<b>Date:</b> 08/08/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM	BE

**DART**

DESIGN DS		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17				TITLE WEARSHOE	SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

**D2658-13****D2658-11****D2658-15**

**NOTES:**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

**RELEASED**  
05-09-08

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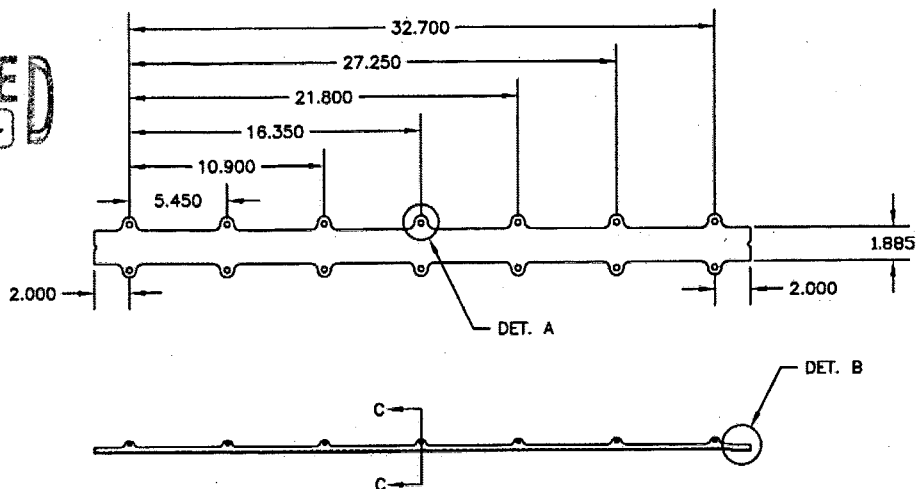
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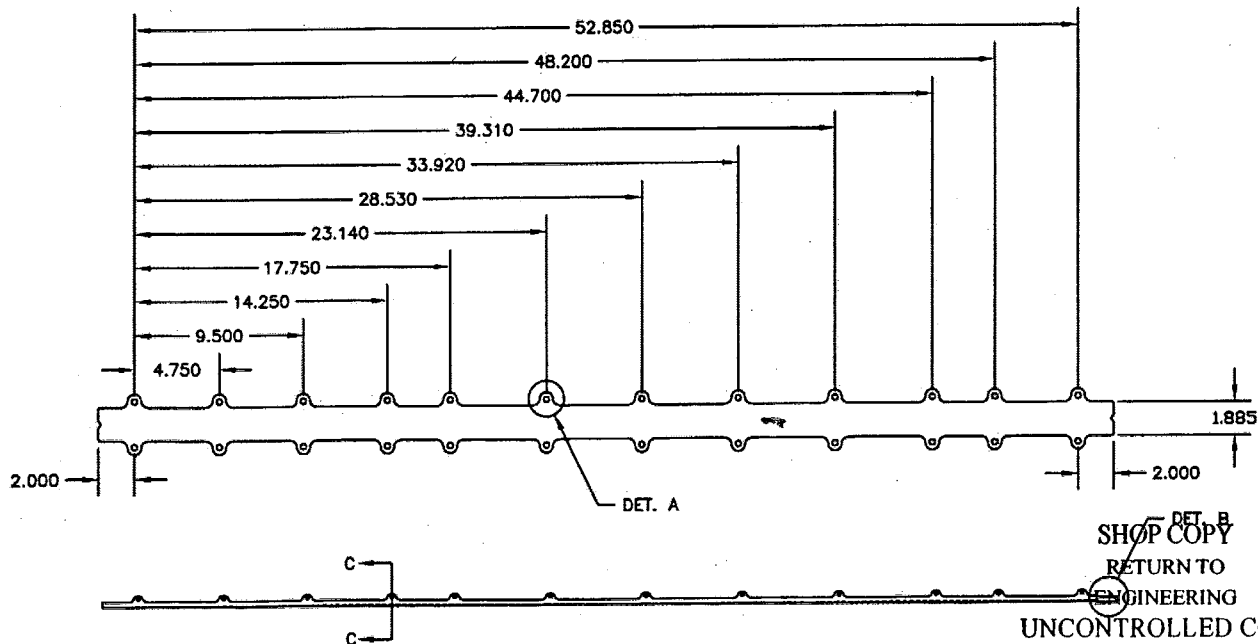
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.07.06 *[Signature]*

**D2656-21**



**D2656-23**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
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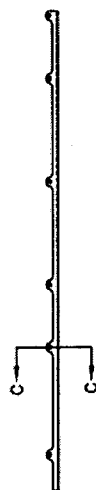
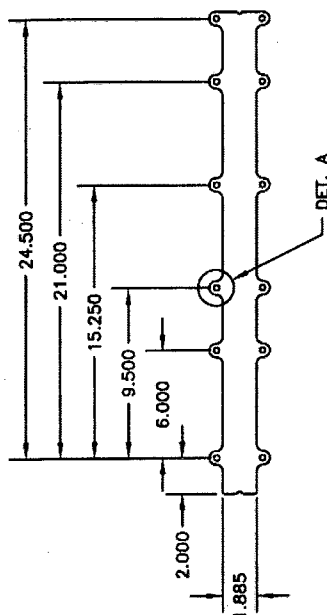
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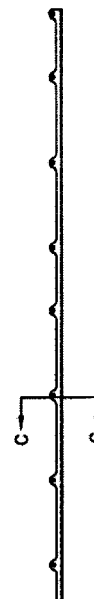
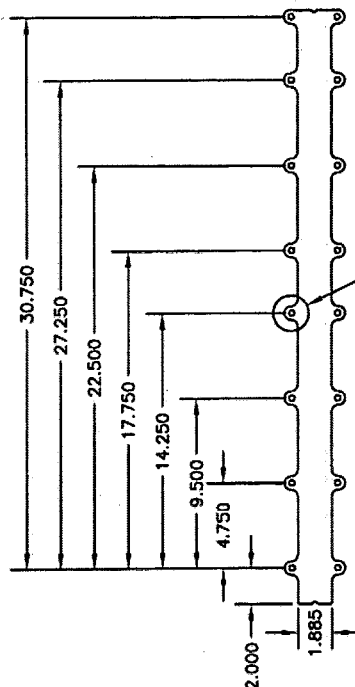


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DATE	05.08.17	TITLE	WEARSHOE	REV. D
				SHEET 3 OF 4
				SCALE 1:10

D2656-33

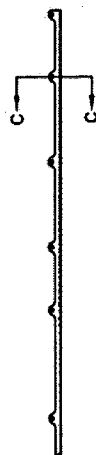
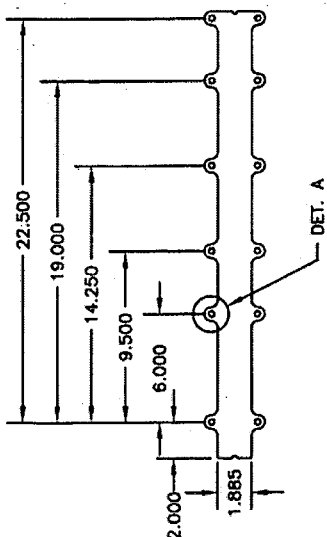


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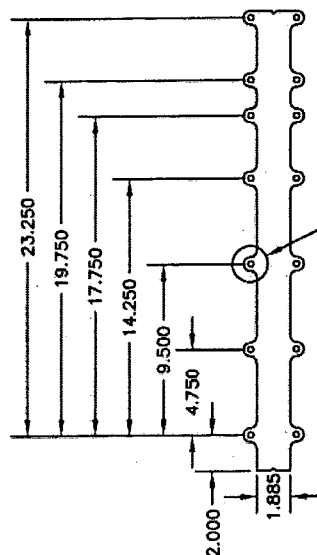


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D2656-31



D2656-35



NOTES:  
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FINISH: SERIES STEEL 20 GAUGE (0.040 THICK)  
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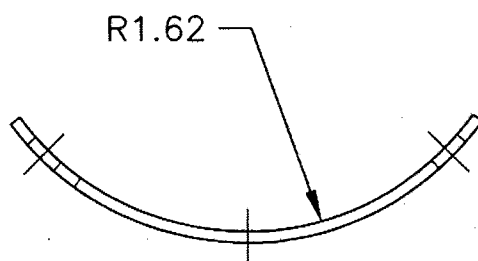
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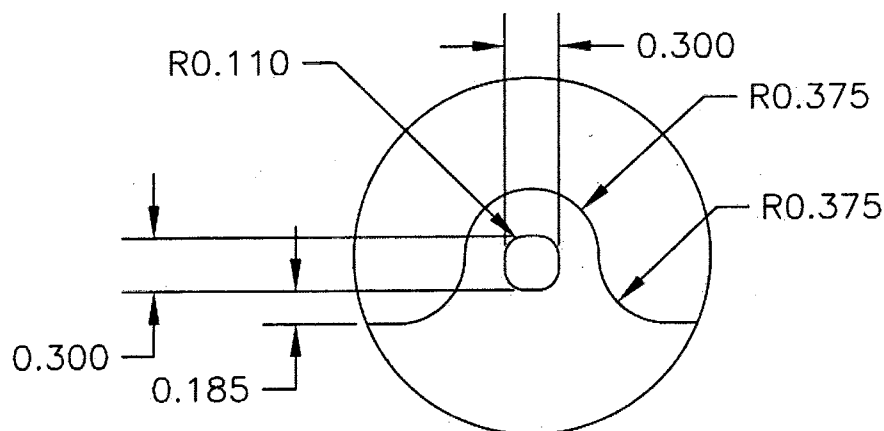
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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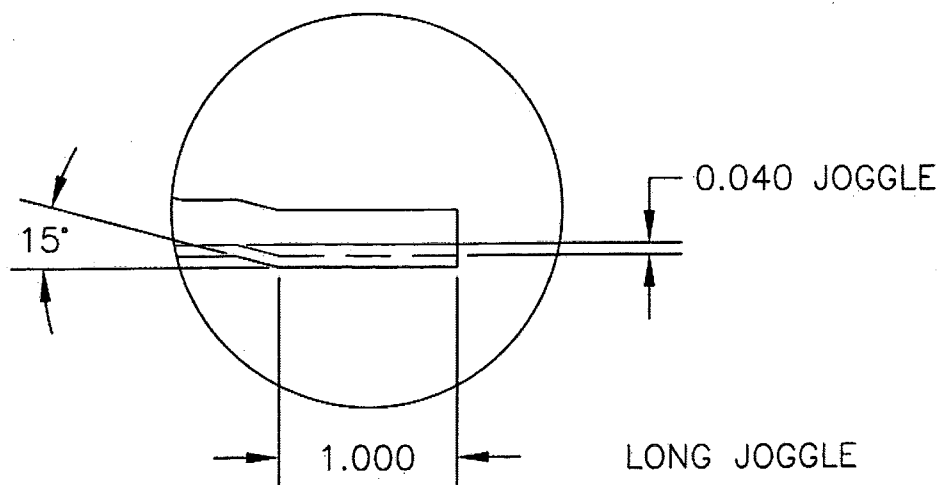


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### DETAIL B



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